

Date: Monday, 02/06/2008 4:32:26 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STRAP		
Job Number	: 39638			Part Number	: D23245		
Estimate Number	: 10729			Drawing Number	: D2324 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 02/06/2008	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 10/06/2008	Qty:	50
Previous Run	: 39583B			Um:	: Each		
Written By	:						
Checked & Approved By	: <u>JW 08.6.02</u>						
Comment	: Est. E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K						
	J/RF						

Additional Product

Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
		
		
	Comment: Qty.: 0.0184 sf(s)/Unit Total : 0.9200 sf(s) 304/316 .063 Sheet	(07772) RB 8-6-6.
2.0	WATER JET	FLOW WATER JET
		
		
	Comment: FLOW WATER JET 1-Cut as per Dwg D2324 Dwg Rev: <u>C</u> Prog Rev: <u>C</u>	RB 8-6-6
	2-Deburr if necessary	→ 08/06/09 61 D Hu
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
		
	Comment: DIMENSIONAL CHECK Inspect dimensions per template D2324-5T1	RB 8-6-6
4.0	QC8	SECOND CHECK
		
		
	Comment: SECOND CHECK	808/06/09 460 counts
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		
		
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 26	AS 08/06/09 x61-

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/10 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/06/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39638
Description: Strut	Part Number:	D2324-5
Inspection Dwg: D2324 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	RB	Audited by:	✓	Prototype Approval:	N/A
Date:	8-6-09	Date:	08/06/09	Date:	N/A

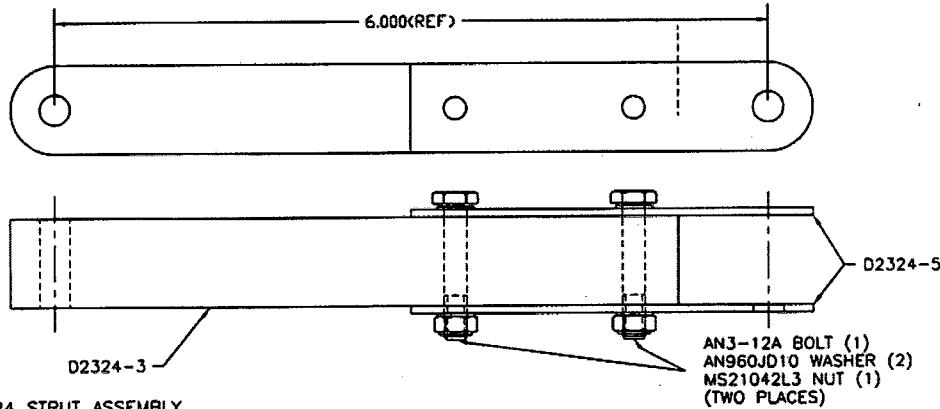
Rev	Date	Change	Revised by	Approved
A	06.06.05	New Issue	KJ/JLM	SM

DART

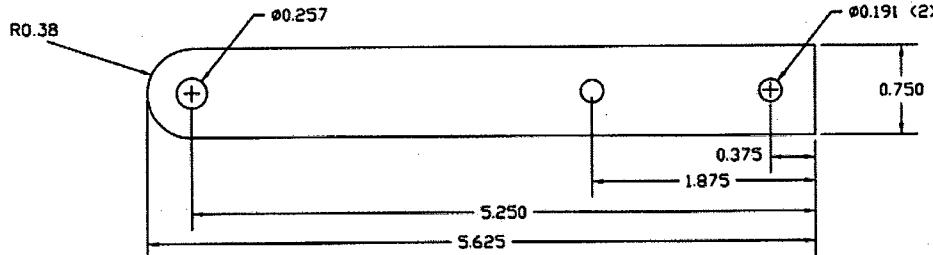
DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2324
DATE 04.12.14	TITLE STRUT	REV. C SHEET 1 OF 1

RELEASED04.12.16 *[Signature]*

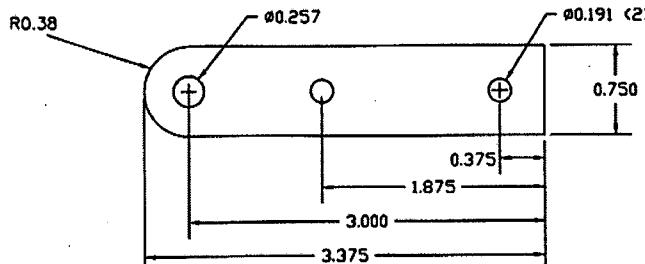
A	94.11.08	NEW ISSUE
B	96.05.07	UPDATE MATERIALS
C	04.12.14	UPDATE NOTES

**D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 591038